

Work Order ID 76369

76369

Page 1

November-10-11 11:51:46 AM

Item ID: D212-664-207 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Low Standard Aft
 Start Date: 10/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D212-664-247	Rev B (DEO)

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D212-664-207 CHG002								

Handwritten: 11-12-12 (1)
 for MLJ 11-12-12 (1)

110	Pick Kit	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging									

Handwritten: mo/JW 11-11-22

120	BENDING MACHINE - CROSSTUBES	0.00							
120									
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT								

Handwritten: mo/JW 11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Start Date: 10/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC15- Crosstube Dimensional Check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.***Use T-Pin***								
	2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551								
	3-Ream hole to finish size in tube as per Dwg D212-664-247								
	4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247								
	5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247								

S u / w / 22

11-11-23
 11-11-24
 11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76369***76369***

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November-10-11 11:51:46 AM

Item ID: D212-664-207

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Crosstubes Chemical Conversion

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat Tube & Cuffs

Mo

11-11-24

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

S u l u / 24

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

S u l u / 24

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Crosstubes	0.00							
210									
Crosstubes	Memo	0.00							
Crosstubes	1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff								
	A/R SIKAFLEX -241/-291 BATCH: <u>119389</u>								
215	QC5- Inspect part completeness to step on W/O	0.00							
215									
QC	Memo	0.00							
Quality Control	***Inspect cuff with T-Pin***								

25 11.11.29

N 11 12 06 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 10/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Spray Painting per QSI005 4.2	0.00							
220	SprayPaint	0.00							
Spray Painting	Memo								
	1-Prime inside and outside crosstube as per QSI 005 4.2								
	2-Paint outside crosstube with White Imron as per QSI 005 4.2								
	PRIME:								
	Start Time: 7:00								
	Finish Time: 7:30								
	PAINT:								
	Start Time: 3:45								
	Finish Time: 4:30								
230	QC14- Inspect Spray Paint	0.00							
230	QC	0.00							
Quality Control	Memo								
	Wrap in plastic bag to protect from scratches								

11-12-08 (1)

11-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Item Name: Crosstube Low Standard Aft
 Start Date: 10/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Pick Kit	0.00							
255									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-664-207								

11/10/12 sp
 11 12 - 12 (1)
 Reo c
 11/12/12 sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 76369***76369***

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November-10-11 11:51:46 AM

Item ID: D212-664-207

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

11/12/13

MK

11-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

November-10-11 11:51:51 AM

Page 1

Work Order ID: 76369

76369

Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07.09.12 EC verified by: JLM
 IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC
 IPP Rev:C ECN 1121 08-02-25 DD verified by: eC
 IPP Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-664-207TRNRevA		Manufactured	No			110	Each	0.0000	1	1	JW	11-11-22	
---------------------	--	--------------	----	--	--	-----	------	--------	---	---	----	----------	--

D212-664-207TRNRevA

Crosstube Turning Detail

D3660-1		Manufactured	No			140	Each	5.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3660-1

CUFF

Location Loc Qty Loc Code

ST477	1	
53501	1	
ST482	4	
71858	1	
75158	3	

CR3212-4-06		Purchased	No			220	Each	678.0000	44	44			
-------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

CR3212-4-06

CHERRY RIVET

Location Loc Qty Loc Code

ST311	678	
112492	18	
112794	360	
119510	300	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

November-10-11 11:51:51 AM

-Work Order ID: 76369

76369

Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3595-063-530

Manufactured No

240

Each

129.0000

4

4

D3595-063-530

RUBBER CUSHION

**

11.12.08

Location

Loc Qty

Loc Code

LG

117

70067

18

72745

58

75783

41

LG055

12

63407

6

67185

6

D2940-1

Manufactured No

240

Each

1.0000

2

2

D2940-1

Support

**

11.12.08

B# 76729

Location

Loc Qty

Loc Code

LG052

1

71308

1

MS21920-28

Purchased No

240

Each

88.0000

4

4

MS21920-28

Clamp(per MIL-DTL-8783C)

**

11.12.08

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

83

116839

2

118713

4

119285

77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

November-10-11 11:51:51 AM

- Work Order ID: 76369

76369

Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3428-1

D3428-1

Placard

Manufactured No

255

Each

11.0000

1

** B76508 P

Location

Loc Qty

Loc Code

ST053

11

73498

11

Purchased No

255

Each

1,562.000

6

** 6

MS21042L6

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST300

562

117677

25

118384

5

118927

48

118968

484

ST518

1000

119075

1000

AN960JD616

NAS1149D0663J

Purchased No

255

Each

0.0000

18

** 18 M119075 P

AN960JD616

Washer

AN6-40A

AN6-40A

Bolt

Purchased No

255

Each

77.0000

4

** 4 11/12/12 P

Location

Loc Qty

Loc Code

ST342

77

117688

1

118422

26

119449

50

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN6-41A

Purchased

No

255

Each

41.0000

AN6-41A

**

2
11/21/12

Location

Loc Qty

Loc Code

ST142

16

118451

16

ST342

25

119449

25

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

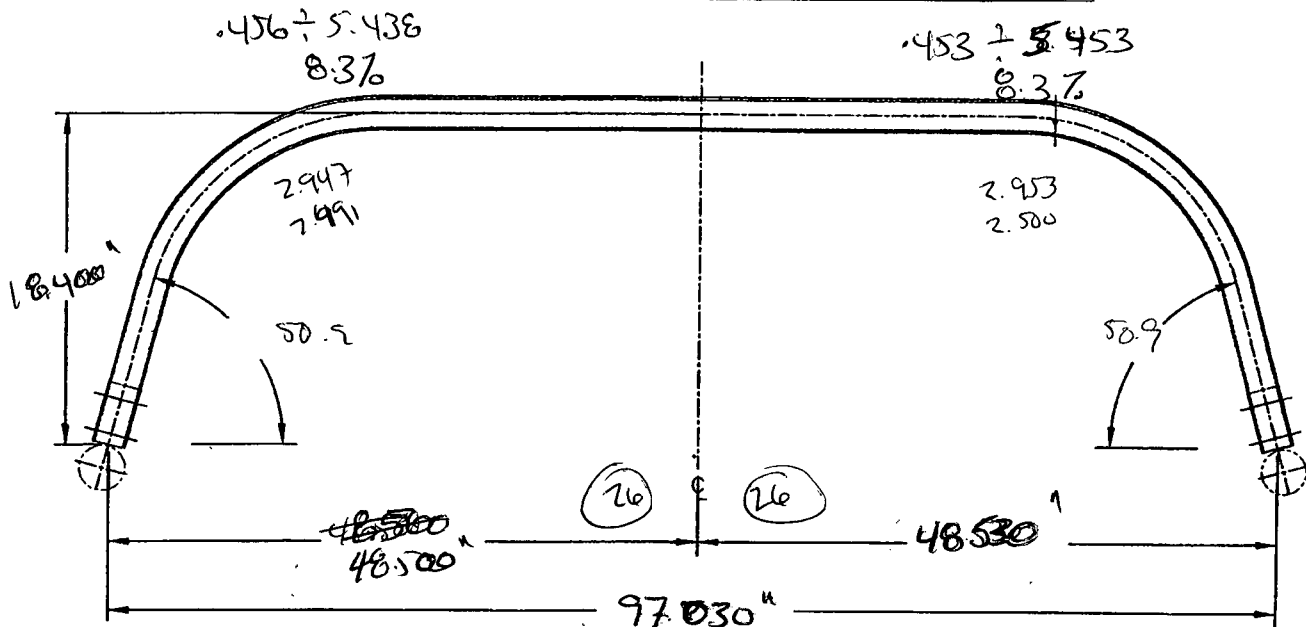
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76369
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments
Sine A = 8.3% crushing @ 26 Passes
Sine B = 8.3% crushing @ 26 Passes
(see note #10)
Acceptable 11.11.22 J1042

QC15 Inspection	<i>[Signature]</i>
Date	11/11/22

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	
B	10.04.01	Dwg Rev updated	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)
D212-664-247B = 36.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD
BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE
UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS
NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76369 M.L.J
11/11/10

DEO ATTACHED

UNDER REVIEW

RELEASED
2009-10-29
WJP

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -247B (ZN C4-2, D5-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-247	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

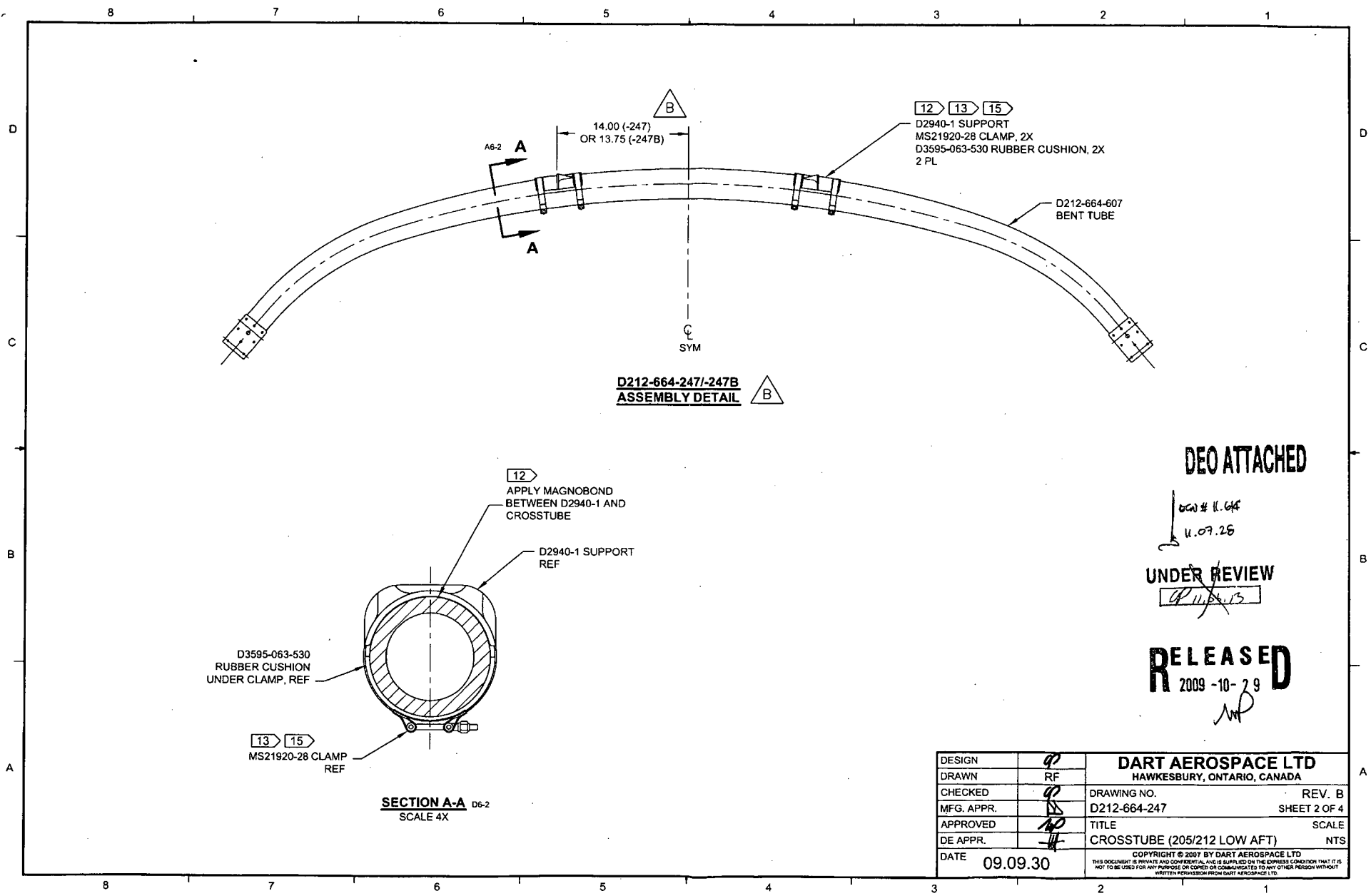
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76369



DEO ATTACHED

OGW # 11.64
11.07.28

UNDER REVIEW

RELEASED
2009-10-29

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	90	D212-664-247	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

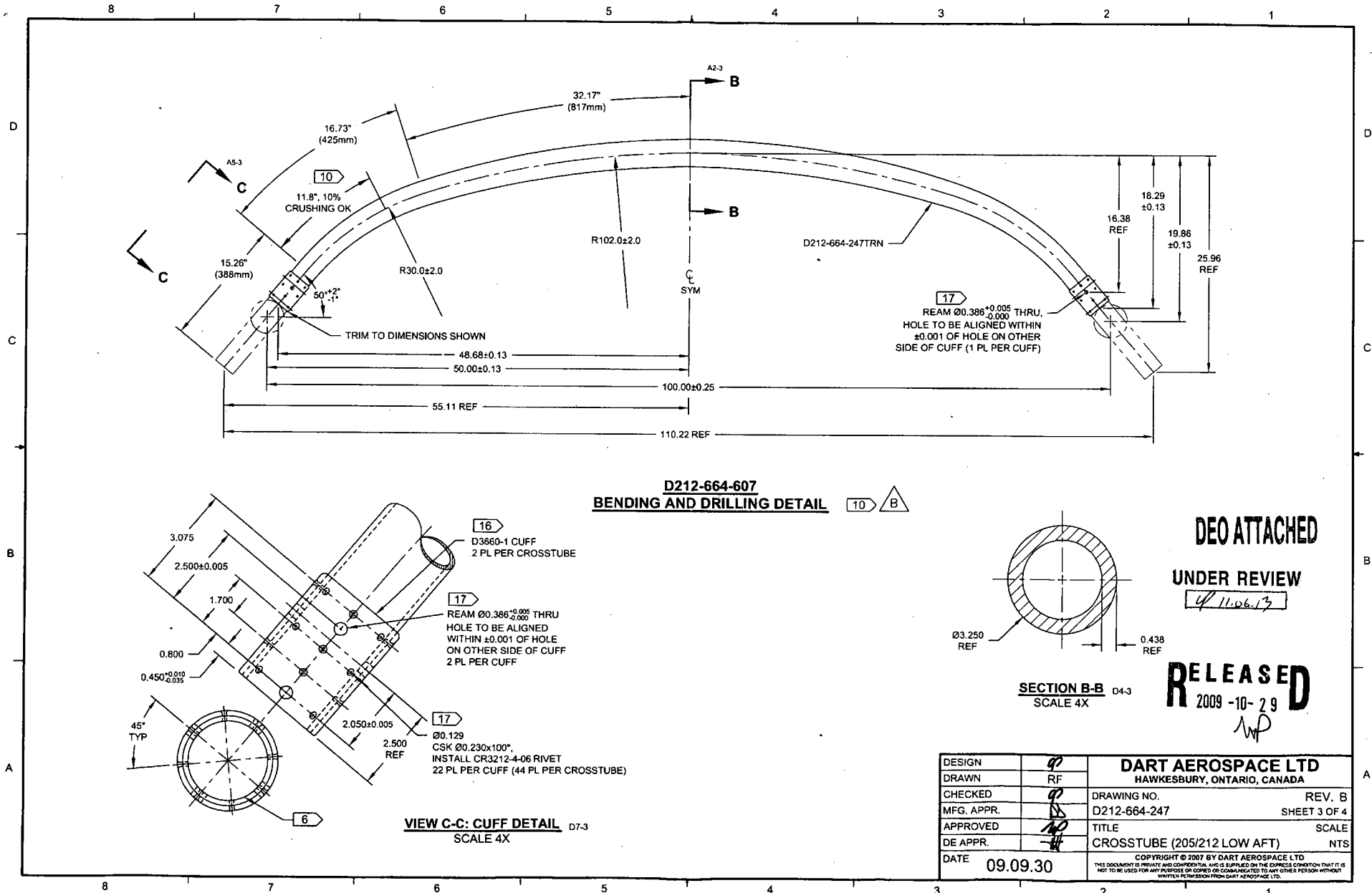
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76369



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

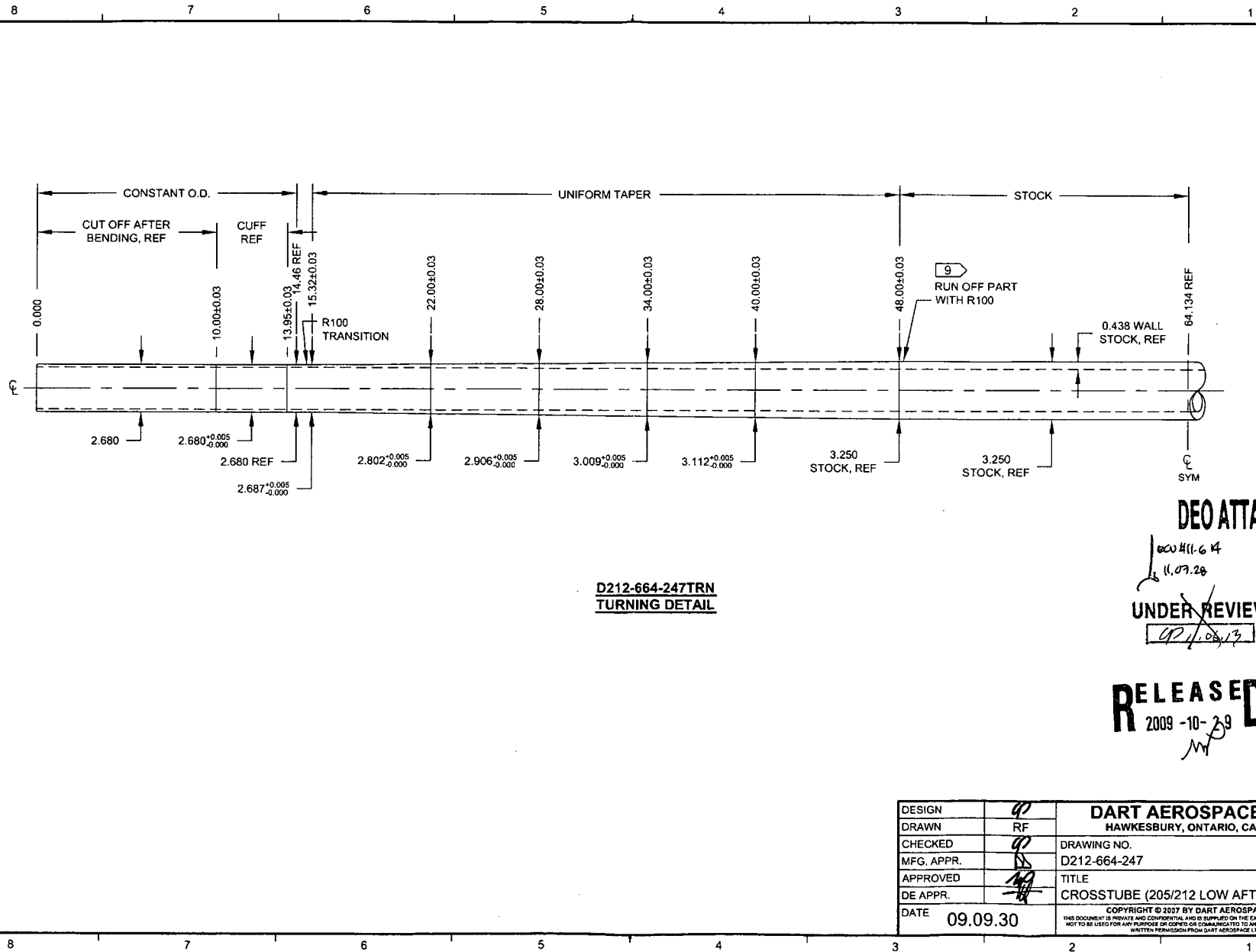
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76369



DEO ATTACHED

BCV H(1.6) K
11.07.28

UNDER REVIEW

02/10/28

RELEASED
2009 -10-29

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	90	D212-664-247	SHEET 4 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76369

DRAWING NO. D212-664-247	TITLE CROSSTUBE ASS'Y (205 LOW AFT)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-247-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED ASS	MFG. APPR. MB	APPROVED MD		DE APPR. MB		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -247	Qty -247B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2940-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
MB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ACUREN

RAPPORT D'INSPECTION PAR RESSUAGE

P - 11200

PAGE 1 DE 2

CLIENT	Dart Aerospace	DATE	November 25 th 2011	HEURE	AM <input checked="" type="checkbox"/> PM <input type="checkbox"/>
ATTENTION	Steve Harris	N° TRAVAIL ACUREN	185-11-0767		
ADRESSE	1770 Aberdeen St Markham, Ontario L3R 9K7	N° CLIENT POWO	18546		
		SITE DE TRAVAIL	Using Dart Markham		
		ACCEPTATION STD.	ASIA 1917/05 C30	DATE/RÉV.	205
PROJET	Inspection Fluorescent en pièces				
ITEM(S) EXAMINÉ	3 x Chromatubes (Aluminium) 6 x Rappel (Aluminium)				

DESCRIPTION DES TRAVAUX	N° PROCÉDURE	LT-002	DATE/RÉV.	2009	N° TECHNIQUE	LT-200	DATE/RÉV.	2009
N° ITEMS	3 Chromatubes avec 6 x Rappel	MATÉRIEL	Aluminium	ÉPAISSEUR				
DESCRIPTION	Fluorescent inspection 100% on surface external on 3 Chromatubes and 6 x Rappel							

DÉTAILS DES INSPECTIONS								
MÉTHODE :	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input type="checkbox"/> LAVABLE À L'EAU	<input type="checkbox"/> MÉTHODE DISSOLVANT	<input type="checkbox"/> PRÉ-ÉMULSIONNANT			
MARQUE :	LUM. NOIRE S/N 16460 <input checked="" type="checkbox"/> PUISS. > 1000 µ W/cm² <input type="checkbox"/> AMBIANT < 2 fc							
PÉNÉTRANT :	Zn-12167	TEMPS PÉNÉTRATION MIN.	10 MIN.	ÉQUIP. LUMIÈRE	<input type="checkbox"/> LAMP. POCHÉ <input type="checkbox"/> LAMP. CULASSE <input type="checkbox"/> PUISS. > 100 fc @ SURFACE			
DISSOLVANT PÉNÉTRANT	E30	TEMPS SÉCHAGE MIN.	> 10 MIN.	AUTRES	LAB 100			
RÉVÉLATEUR	50502	TEMPS PÉNÉTRATION MIN.	10 MIN.	MÈTRE LUM.	N/S	DATE CAL DUE		
TYPE RÉVÉLATEUR	<input checked="" type="checkbox"/> NON AQUEUX	<input type="checkbox"/> AQUEUX	<input type="checkbox"/> SEC					

SURFACE INSPECTÉE					
CONDITION SURFACE	<input type="checkbox"/> MEULÉE	<input type="checkbox"/> SOUDÉE	<input type="checkbox"/> MACHINÉE	<input type="checkbox"/> GRENAILLÉE	<input type="checkbox"/> MÉTAL PROPRE
TEMPÉRATURE SURFACE	<input type="checkbox"/> < - 4°C / 20°F	<input type="checkbox"/> - 4°C / 20°F DE 10°C / 50°F	<input checked="" type="checkbox"/> 10°C / 50°F DE 52°C / 125°F	<input type="checkbox"/> > 52°C / 125°F	

RÉSULTATS-	<input type="checkbox"/> MÉTRIQUE	<input type="checkbox"/> IMPÉRIAL
------------	-----------------------------------	-----------------------------------

3 x Chromatubes (see other ✓ start p. 2 item)	Notre indication ne fait
6 x Rappel (see other ✓ start p. 2 item)	de notre indication ne fait
ET 11-11-28,	

Étendue des Services

L'entente selon laquelle le Groupe Acuren Inc. exécute les services ne concerne que les énoncés par écrit. En aucune circonstance ces services ne s'étendent au-delà de l'exécution des services demandés. Il est entendu que toutes les descriptions, les observations et les expressions d'opinions faites par Acuren reflètent les opinions ou les observations de l'entreprise fondées sur l'information et les hypothèses fournies par le propriétaire/opérateur, et elles ne constituent pas des déclarations ou des garanties ou ne peuvent être interprétées comme constituant. Le Groupe Acuren Inc. n'assume aucune des responsabilités du propriétaire/opérateur, et le propriétaire/opérateur conserve la responsabilité entière des décisions prises en matière d'ingénierie, de fabrication, de réparation et d'usage à partir de l'information ou des données fournies par Acuren en rapport avec les services décrits dans les présentes ne peuvent excéder le coût des services rendus.

Norme de Diligence

Dans l'exécution des services, le Groupe Acuren Inc. applique le degré de diligence, le soin et la compétence normalement exercés dans des circonstances semblables par d'autres fournisseurs de ce type de services opérant dans la même localité ou dans une localité similaire. Aucune autre garantie, implicite ou explicite, n'est faite ou voulue par le Groupe Acuren Inc.

SIGNATURES

REPRÉSENTANT	MOULÉ	SIGNATURE	FTJ #	
TECHNICIEN (SIGNATURE):			RAPPORT RÉVISÉ PAR:	
NOM (MOULÉ):			NOM	INITIALES
1 ^{ER} TECHNICIEN	ONGC NIVEAU 2	SNT NIVEAU 2	ONGC NIVEAU	SNT NIVEAU
ONGC N° REG.	12265		ONGC N° REG.	



RAPPORT D'ESSAI NON DESTRUCTIF

(SUITE)

RAPPORT #

R-11200

PAGE 2 DE 2

CLIENT	1-201 Aerospine	DATE	Quatre 25 ^{ème} 2011	HEURE	<input checked="" type="checkbox"/> AM <input type="checkbox"/> PM
ATTENTION	Yves Laroche Lucelle	NO. TRAVAIL ACUREN	188-11-0767		
RÉSULTATS	(<input type="checkbox"/> METRIQUE <input type="checkbox"/> IMPÉRIAL)				

Aluminium cressobus:

1	work order	ID	75804 (cressobus bw)	Item ID	D 312-664-205
2	"	"	75803	"	"
3	"	"	75351 (cressobus AFT)	"	D 412-664-205
4	"	"	76350	"	"
5	"	"	75804 (cressobus bw)	"	D 212-664-205
6	"	"	76370	"	"
7	"	"	76369	"	"

Aluminium Rappel:

8	work order	ID	76101 (Rappel)	Item ID	D 3011-1
---	------------	----	----------------	---------	----------

11-11-28

Étendue des Services

L'entente selon laquelle le Groupe Acuren Inc. exécute les services ne concerne que les énoncés par écrit. En aucune circonstance ces services ne s'étendent au-delà de l'exécution des services demandés. Il est entendu que toutes les descriptions, les observations et les expressions d'opinions faites par Acuren reflètent les opinions ou les observations de l'entreprise fondées sur l'information et les hypothèses fournies par le propriétaire/opérateur, et elles ne constituent pas des déclarations ou des garanties ou ne peuvent être interprétées comme constituant. Le Groupe Acuren Inc. n'assume aucune des responsabilités du propriétaire/opérateur, et le propriétaire/opérateur conserve la responsabilité entière des décisions prises en matière d'ingénierie, de fabrication, de réparation et d'usage à partir de l'information ou des données fournies par Acuren en rapport avec les services décrits dans les présentes ne peuvent excéder le coût des services rendus.

Norme de Diligence

Dans l'exécution des services, le Groupe Acuren Inc. applique le degré de diligence, le soin et la compétence normalement exercés dans des circonstances semblables par d'autres fournisseurs de ce type de services opérant dans la même localité ou dans une localité similaire. Aucune autre garantie, implicite ou explicite, n'est faite ou voulue par le Groupe Acuren Inc.

SIGNATURES

REPRÉSENTANT À LA CLIENTÈLE	<u>Ben Tiley</u>	MOULÉE	<u>[Signature]</u>	SIGNATURE	FTJ #:	
TECHNICIEN (SIGNATURE)	<u>[Signature]</u>					
NAME (MOULÉE):	<u>Ben Tiley</u>	1 ^{er} TECHNICIEN	<u>[Signature]</u>	2 ^e TECHNICIEN	RAPPORT REVISÉ PAR:	
		NIVEAU CGSB <u>2</u> NIVEAU SNT <u>2</u>	NIVEAU CGSB	NIVEAU SNT	NOM	INITIALES
		No. ENREG. CGSB <u>13205</u>	No. ENREG. CGSB			

H-3050

BLANCHE - COPIE DU CLIENT

JAUNE - COPIE DU BUREAU

ROSE - COPIE DU TECHNICIEN

OR - COPIE DU BUREAU

5.2 STANDARD GEAR CROSSTUBES

Item	-107	-207	-209	Part Number	Description
	X			D212-664-107	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
		X		D212-664-207	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
			X	D412-664-209	CROSSTUBE INSTALLATION, 412 STANDARD AFT
6	1			D212-664-147	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
7		1		D212-664-247	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
8			1	D412-664-249	CROSSTUBE ASSEMBLY, 412 STANDARD AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
45	2			* D3659-1	CUFF
46		2	2	* D3660-1	CUFF
47	44	44		* CR3212-4-06	RIVET (M7885/3-4-06)
48			44	* CR3212-4-07	RIVET (M7885/3-4-07)
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-147/-247 OR D412-664-249 ASSEMBLIES ABOVE
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI
SKIDTUBES.